

SHIP Sept Monday  
14th

# Work Order ID 52023

September 11, 2009 2:14:37 PM



Page 1

Item ID: D412-698-031  
Revision ID: E  
Item Name: Cabin Door Roller, LH

Accept



Setup Start



Stop



Start Date: 09/14/2009 Start Qty: 4.00  
Required Date: 09/14/2009 Req'd Qty: 4.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: MC  
QC: \_\_\_\_\_

Date: 09-09-11

Tooling:

Date: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E								

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-031

CHG001

802/09/14

for BG 09/09/14

110 0.00



Pick Kit

Packaging

Memo

0.00

Packaging

802/09/14 (4)

120 0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

=> 802/09/14

802/09/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 52023**

September 11, 2009 2:14:37 PM



Page 2

Item ID: D412-698-031

Accept



Setup Start



Revision ID: E

Stop



Item Name: Cabin Door Roller, LH

Start Date: 09/14/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D412-698-031 □ Location: \_\_\_\_\_ □ PPP Rev: A

9/14/14 (4x) SF

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/09/14 HJ

BF 09-9-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 11, 2009 2:14:37 PM

Page 1

Work Order ID: 52023

Parent Item: D412-698-031RevE

Parent Item Name: Cabin Door Roller, LH

Start Date: 09/14/2009

Required Date: 09/14/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3121-143RevE 1x Manufactured No

120

Each

9.0000

4.0000



Bracket Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

46036

9

120

Each

48.0000

4.0000

D3137-043RevF 1x Manufactured No



Bracket Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48

29725

4

42192

44

120

Each

19.0000

4.0000

D3183-043RevC1 1x Manufactured No



Bracket Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

42193

4

46030

10

47647

5

09/15/14 (4)

09/15/14 (4)

09/15/14 (4)

29725 3x  
B42192 1x

B42193

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 11, 2009 2:14:37 PM

Work Order ID: 52023



Parent Item: D412-698-031RevE



Parent Item Name: Cabin Door Roller, LH

Start Date: 09/14/2009

Required Date: 09/14/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

S #	D3202-3RevD	1P	Manufactured	No		120	Each	9.0000	4.0000	✓		
											B42516	09/19/14
	Cover											

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

9

42516

9

S  
# D3674-041RevA 9X Manufactured No

120

Each

48.0000

12.0000 ✓



BRACKET ASSEMBLY



09/19/14 (4)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

48

40122

3

42514

39

47645

6

S  
# D3675-1RevB 9X Manufactured No

120

Each

84.0000

36.0000 ✓



SLIDING DOOR BRACKET



B42514  
B42516

09/19/14 (4)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

84

40347

4

42515

80

42515

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**52.18 PARTS LIST - DOOR MODIFICATION KITS**

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description
X						D412-698-019	BEARING OVERHAUL KIT
	X					D412-698-021	REPLACEMENT SHIM KIT
		X				D412-698-031	CABIN DOOR ROLLER KIT, LH
			X			D412-698-032	CABIN DOOR ROLLER KIT, RH
				X		D412-698-033	REPLACEMENT DOOR TRACK KIT
					X	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
1						D3137-3	GUIDE
1						D3137-5	WASHER
2						D3183-045	BEARING ASSEMBLY
	3					D3238-1	SHIM
	1					D3238-3	SHIM
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
			1			D3121-144	BRACKET ASSEMBLY
		1	1			D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
			1			D3183-044	BRACKET ASSEMBLY
		1	1	1		D3202-3	COVER
		3	3			D3674-041	BRACKET ASSEMBLY
		9	9	9		D3675-1	BRACKET
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
					2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
					12	AN960JD10L	WASHER
					12	MS21042L3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW

REFERENCE ONLY

52000

• COPYRIGHT © 2003 BY DART AEROSPACE LTD. •  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**52-00-00**